

Work Order ID 56101

February 10, 2010 12:16:43 PM



Page 1

Item ID: D3535-37

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/10/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10-2-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 10-2-12

⑬

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

Quality Control

0.00

B 10-2-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

Quality Control

0.00

13

10-2-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

February 10, 2010 12:16:43 PM

Accept

Setup Start

Stop

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Start Date: 2/10/10 **Start Qty:** 12.00

Required Date: 2/26/10 **Req'd Qty:** 12.00

Customer:

Reference:

Run Start

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Draw Number

**Draw
Rev.**

**Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

130

0.00

Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. 2-Identify as D3535-37

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

Grey Sandtex(Ref:4,3,5,6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:15pm OVEN TEMPERATURE: 320°F
FINISH TIME: 3:45pm

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Work Order ID 56101

February 10, 2010 12:16:43 PM

Page 3

Item ID: D3535-37

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Setup Start

Revision ID:

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Item Name: Wearshoe

Start Date: 2/10/10 Start Qty: 12.00

Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

PR 10-3-3

(B)

Ø



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: FP-18

0.00

MH 10/03/03

(X13)

Ø



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

MF

10-3-2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

February 10, 2010 12:16:47 PM

Work Order ID: 56101



Parent Item: D3535-37



Parent Item Name: Wearshoe

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM

Start Qty: 12.00

Required Qty: 12.00

Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	229.1294	10.0484	11,		



B 10-2-12

304/316 .040 Sheet

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

MAT	229.1294053	
110076	0.40253684	
112567	38.0765789	
112885	36.9578	
113062	145.1723	
113077	8.52018947	

113062

13

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DART AEROSPACE LTD		Work Order:	56101
Description: Wearshoe		Part Number:	D3535-37
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.193	X			
0.300	+/-0.010	.307	X			
0.300	+/-0.010	.306	X			
1.885	+/-0.010	1.988	X			
2.000	+/-0.010	2.001	X			
4.750	+/-0.010	4.756	X			
9.500	+/-0.010	9.506	X			
14.250	+/-0.010	14.250	X			
17.750	+/-0.010	17.756	X			
22.500	+/-0.010	22.500	X			
27.250	+/-0.010	27.250	X			
30.750	+/-0.010	30.750	X			
6.00	+/-0.030	6.00	X			
8.00	+/-0.030	8.00	X			
16.00	+/-0.030	16.06	X			
21.00	+/-0.030	21.00	X			
0.040	+/-0.010	.034	X			

Measured by: IB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-2-12	Date: 10-2-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ [Signature]	[Signature]

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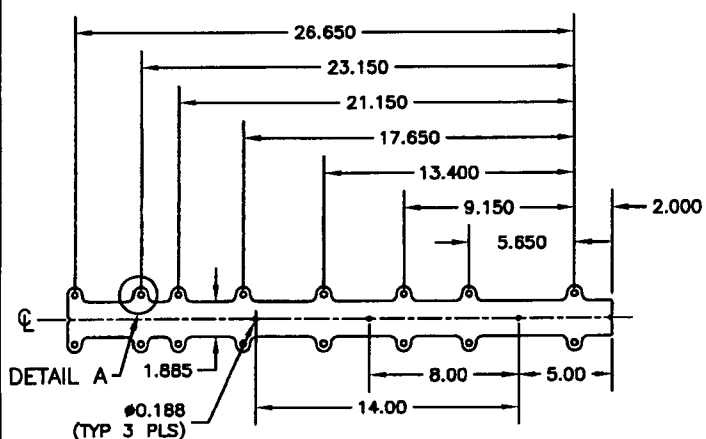
NOTE: Date & initial all entries

DART

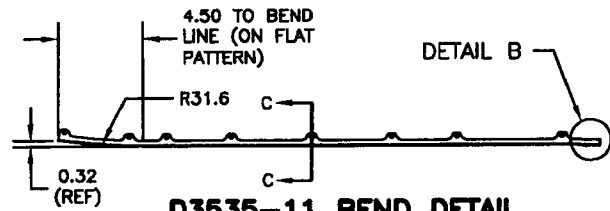
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07.04.24

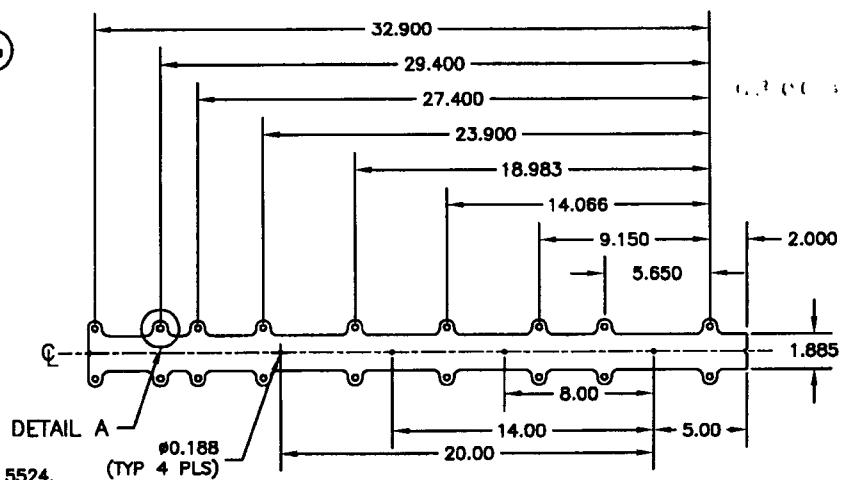
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34101
B810-2-10



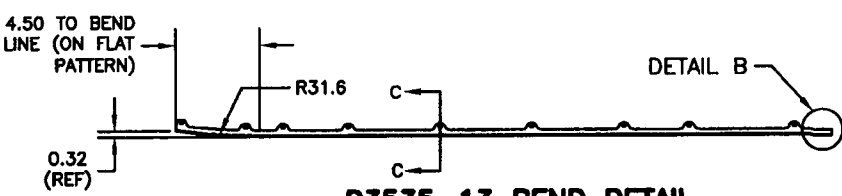
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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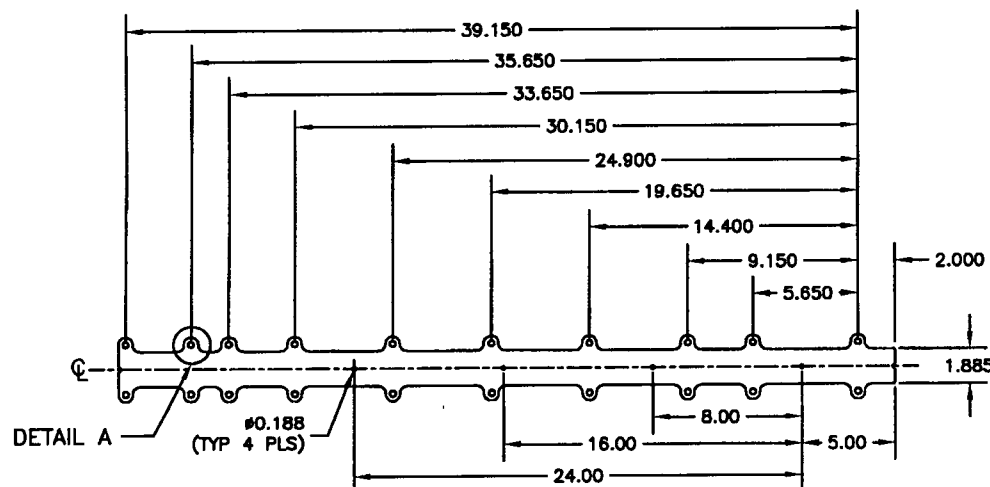
NOTE: Date & initial all entries

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07.04.24

W/D 56101

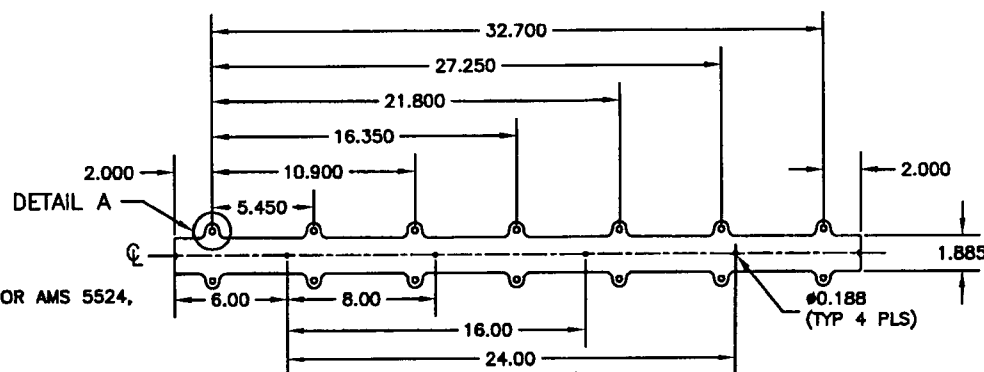


D3535-15F FLAT PATTERN

4.50 TO BEND
LINE (ON FLAT
PATTERN)

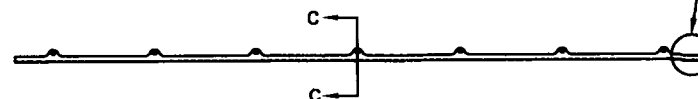
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(REF)

D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN

DETAIL B



D3535-21 BEND DETAIL

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CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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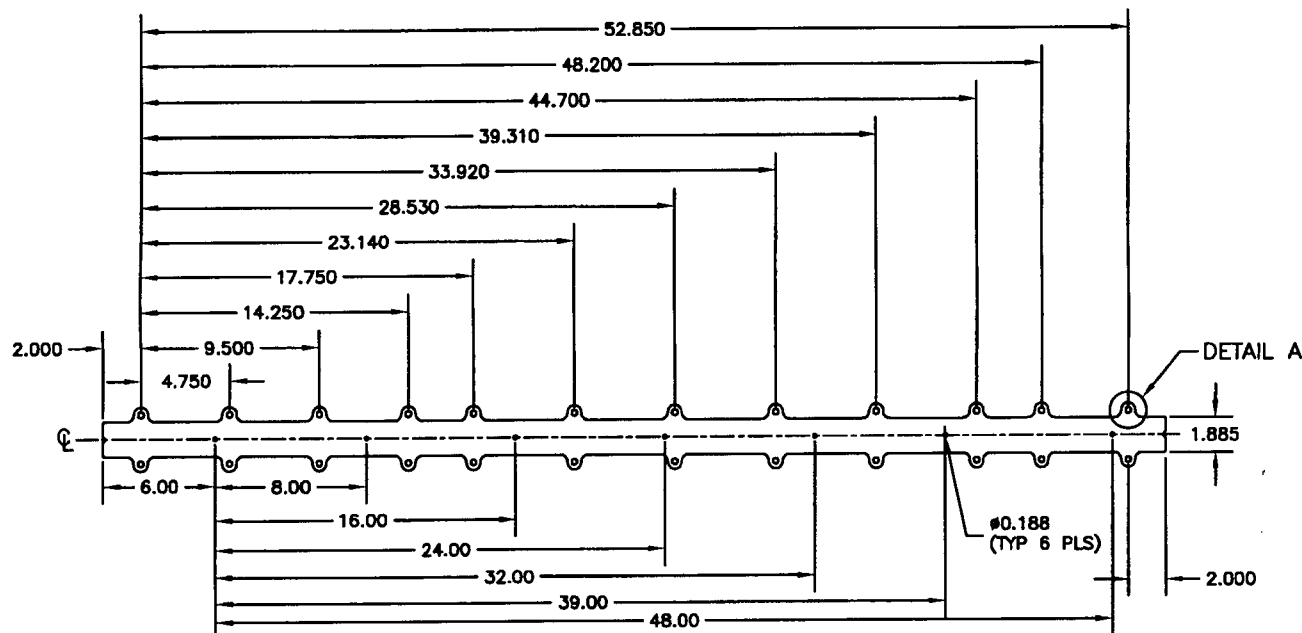
NOTE: Date & initial all entries

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07.04.24

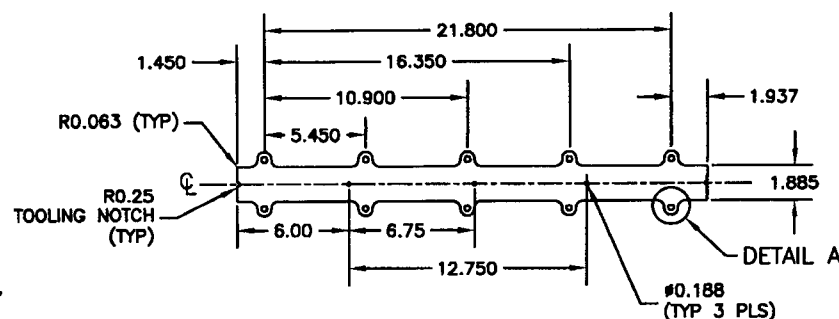
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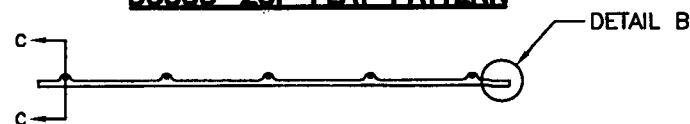
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

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CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 3 OF 7
		SCALE 1:10

W/O:		WORK ORDER CHANGES					
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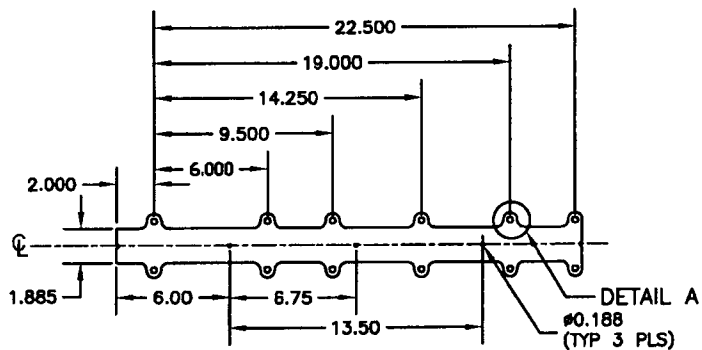
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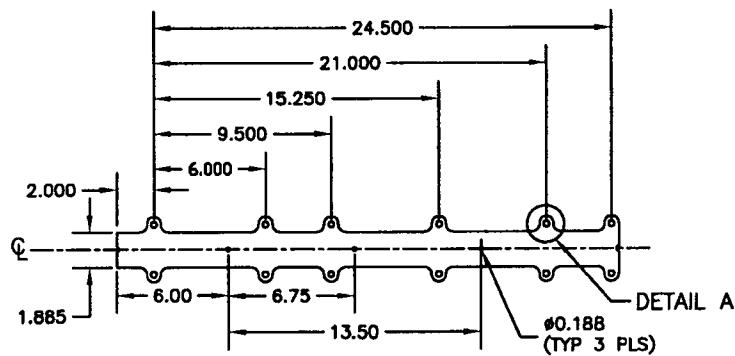


D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL

W10 56101



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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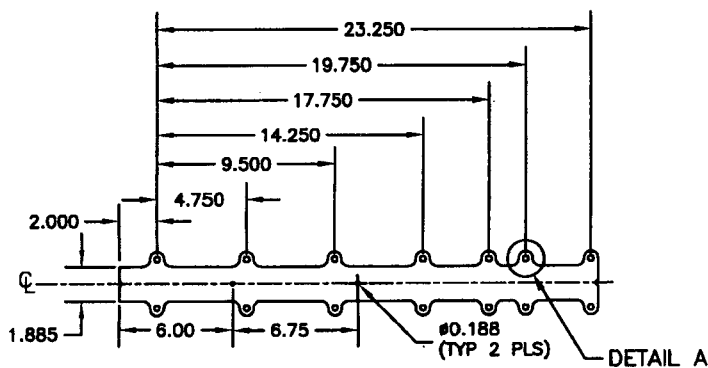
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07.04.17

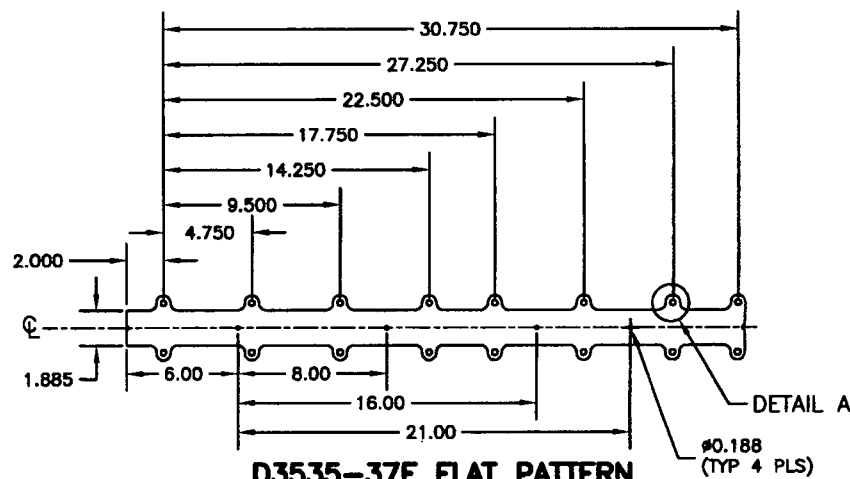
w/o 56101



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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		SCALE	1:10	
		REV. B	SHEET 5 OF 7	

W/O:		WORK ORDER CHANGES					
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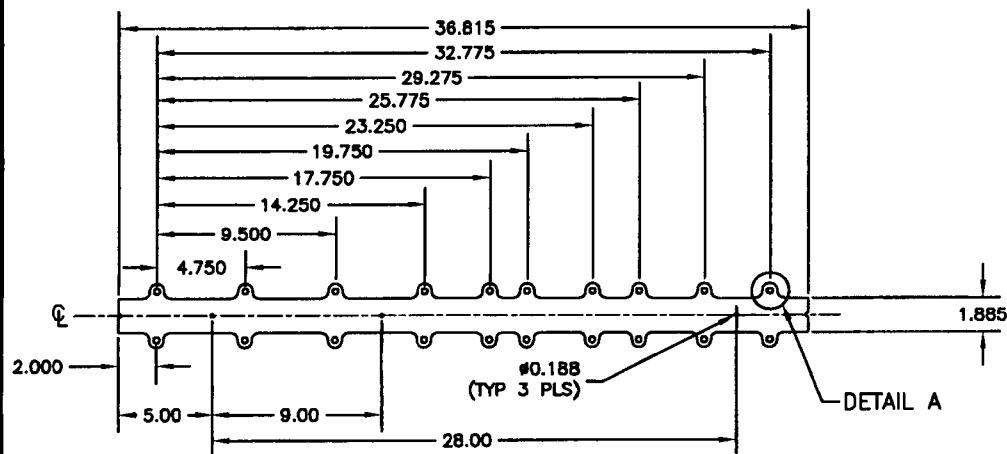
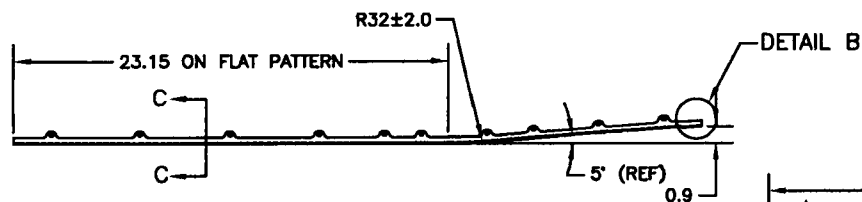
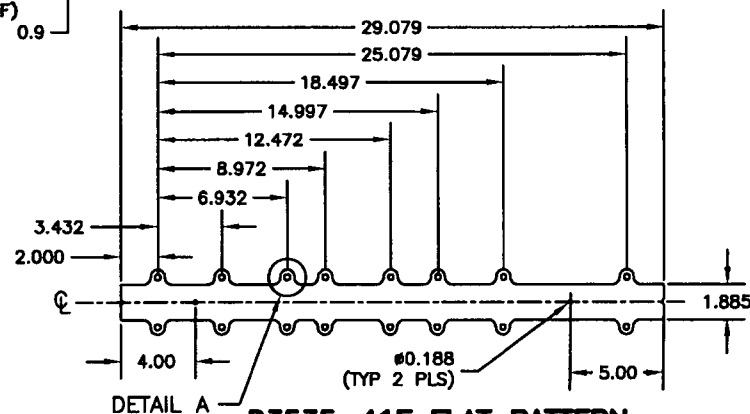
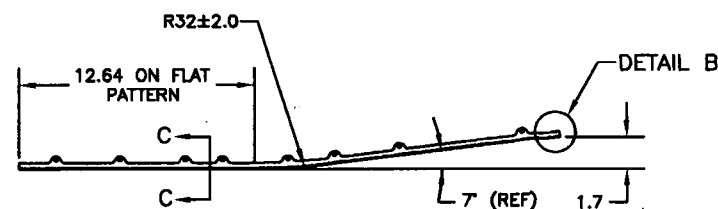
NOTE: Date & initial all entries

DART

RELEASED

07.04.17

wlo 56101

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10

W/O:		WORK ORDER CHANGES					
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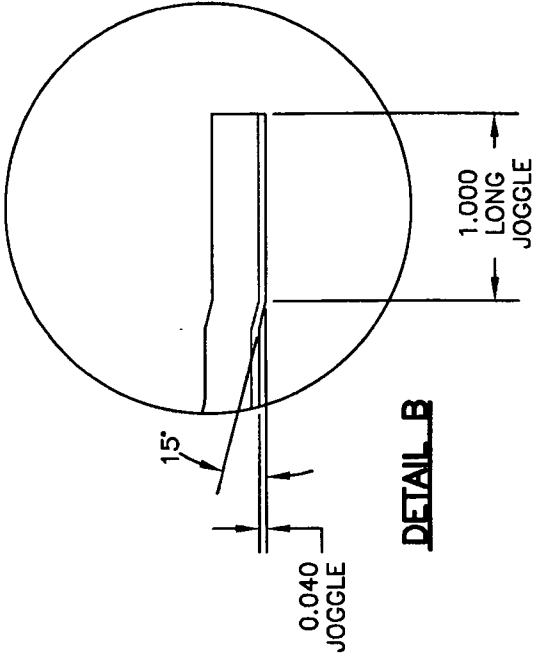
NOTE: Date & initial all entries



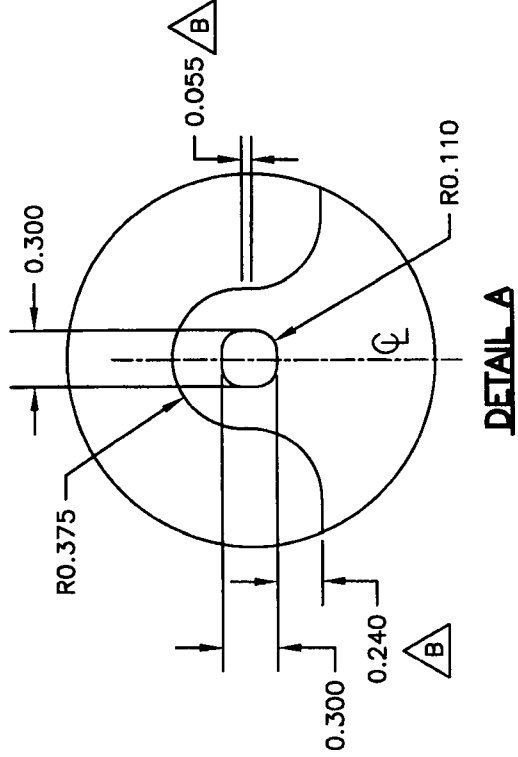
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED
07.04.24

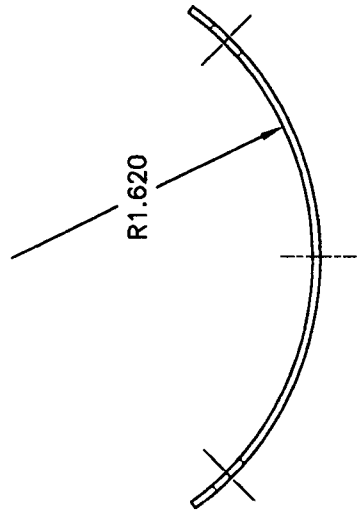
u/o 56101



DETAIL B



DETAIL A



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries